

Date: Tuesday, 03/06/2008 1:03:23 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	R44 BEARPAW
<b>Job Number</b> :	39667A		
<b>Estimate Number</b> :	12480		
<b>P.O. Number</b> :		<b>Part Number</b> :	D35291
<b>This Issue</b> :	03/06/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3529 REV A
<b>First Issue</b> :	//	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	38021A	<b>Drawing Revision</b> :	A
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>JUL 08-6-03</u>	<b>Due Date</b> :	20/06/2008
<b>Comment</b> :	Est Rev:A New Issue 06-06-28 JLM		

Qty: 8 PCS. Um: Each  
*Not 8 sets*

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------



**Comment:** Qty.: 1.3283 sf(s)/Unit Total : 10.6260 sf(s)  
 Pick:  
 blank: 13.5" x 13.000" x 1.00" thick (+0.030/-0.000)  
 Material: Black UHMW 1"(MUHMWB10)  
 Batch: M108013

*M.A 08/06/04*

2.0	MFG ENGINEERING	MFG ENGINEERING
-----	-----------------	-----------------



**Comment:** MFG ENGINEERING  
 Program Batch Number

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #1

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA645 and Dwg D3529

3-Deburr

*M.A/JL 08/06/09*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*M.A/JL 08/06/09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 03/06/2008 1:03:23 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: R44 BEARPAW

Job Number: 39667A

Part Number: D35291

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 08/06/10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PP 39667

P 8/7/01 y hit

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/02 JF

Job Completion



MF 08-07-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	39667A
Description: Bearpaw		Part Number:	D3529-1
Inspection Dwg: D3529 Rev: A		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.50	+/-0.030	5.50	✓			
B	0.07 x 45°	+/-0.030 x 0.5°	0.040	✓			
C	R0.25	+/-0.030	R0.25	✓			
D	0.250	+/-0.010	0.240	✓			
E	0.625	+/-0.010	0.622	✓			
F	0.950	+/-0.010	0.949	✓			
G	1.63	+/-0.030	1.620	✓			
H	12.14	+/-0.030	12.140	✓		tape	
I							
J	5.70	+/-0.030	5.710	✓			
K	0.375	+/-0.010	0.369	✓			
L	0.525	+/-0.010	0.519	✓			
M	0.13 x 45°	+/-0.030 x 0.5°	0.130 x 45°	✓			
N	R0.50	+/-0.030	R0.50	✓			
O	12.76	+/-0.030	12.76	✓		tape	
P	3.38	+/-0.030	3.373	✓			
Q	3.75	+/-0.030	3.375	✓			
R	5.187	+/-0.010	5.190	✓			
S	5.25	+/-0.030	5.252	✓			
T	7.13	+/-0.030	7.128	✓			
U	Ø0.260	+0.006/-0.001	Ø0.260	✓			
V	0.30	+/-0.030	0.300	✓			
W	0.93	+/-0.030	0.928	✓			
X	1.30	+/-0.030	1.271	✓			

Measured by: M.A.	Audited by: J.F.	Prototype Approval:	N/A
Date: 08/06/09	Date: 08/06/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.05.06	Dimension I removed	KJ/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

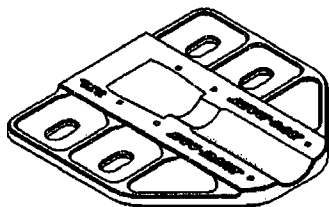
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

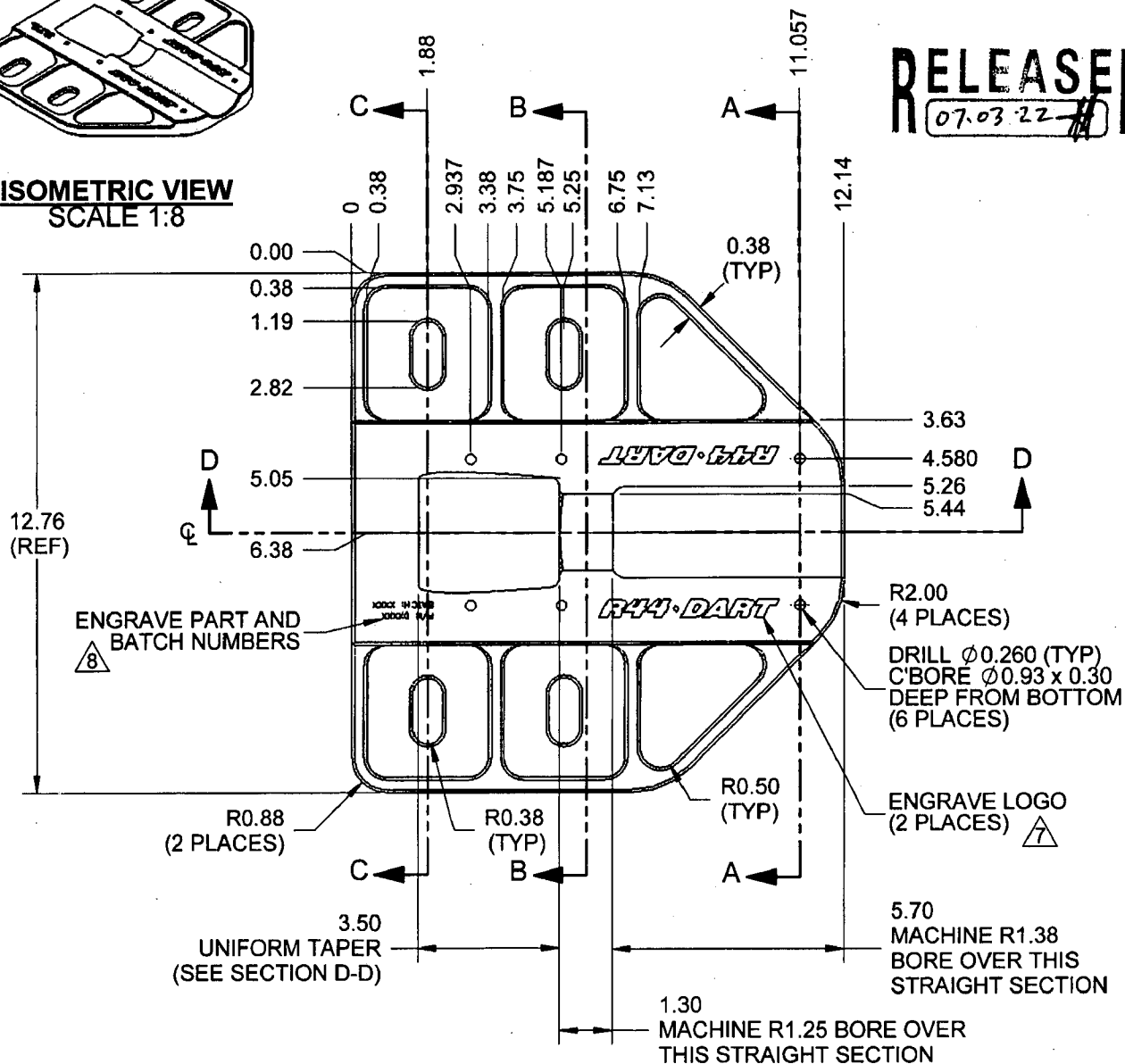
NOTE: Date & initial all entries

**DART**

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3529	REV. A SHEET 1 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE	



**ISOMETRIC VIEW**  
SCALE 1:8



**D3529-1 R44 BEARPAW**

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT  $\varnothing$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

SHOP COPY  
RETURN TO

ENGINEERING  
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 3866717

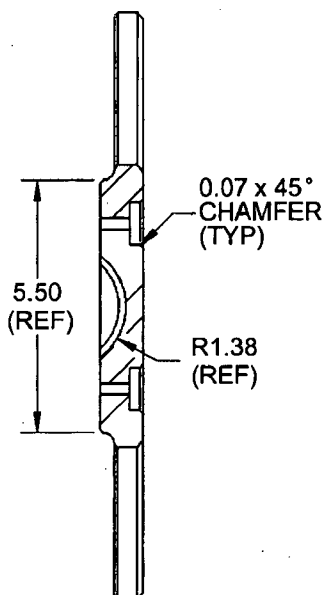
COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

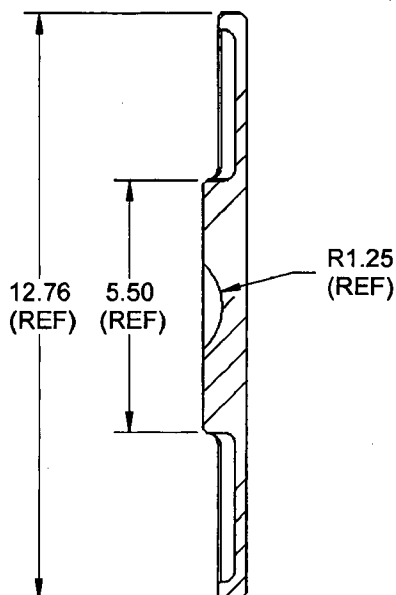


DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3529	REV. A SHEET 2 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4

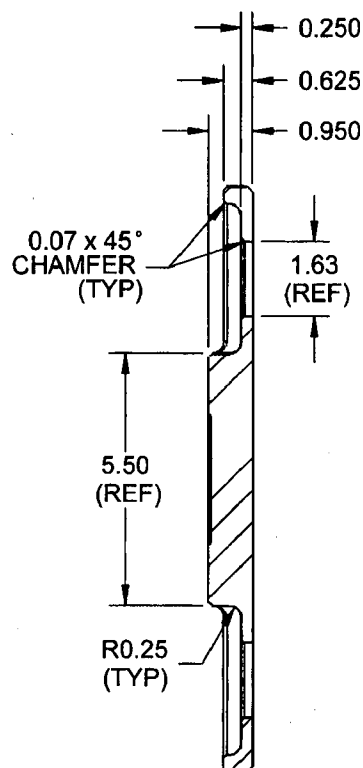
RELEASED  
07.03.22



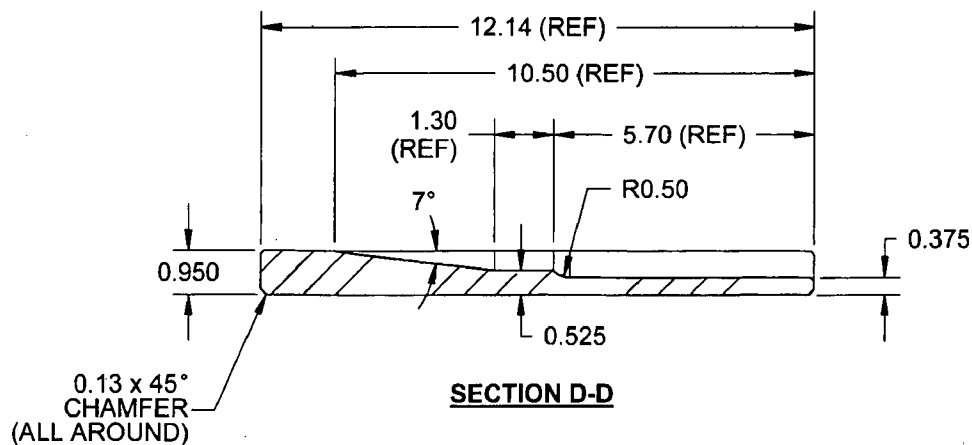
SECTION A-A



SECTION B-B



SECTION C-C



SECTION D-D

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39667A

COPYRIGHT © 2007 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.